



Dart Aerospace Ltd.
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D2893-1**Job Sheet 194240****Part No:** D2893-1**Job Qty:** 12 pcs**Part Name:** Support**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/29/19**Job Tracking No:****Due Date:** 5/31/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV C IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15 add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C DD verf:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	HAAS 4 Axis	12 pcs	5/31/19	5/31/19	0.33	23.53	HAAS - 1	DAS 71 9-89 19-6-8
							HAAS - 2	
							HAAS - 3	
							HAAS - 4	
120	QC 8	12 pcs	5/31/19	5/31/19	0.00	0.00	QC 8 - 12	D.A 19-06-11
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
130	Crosstubes - 2 - B4B	12 pcs	5/31/19	5/31/19	0.00	2.00	Crosstubes - 1 - B4B	
							Crosstubes - 2 - B4B	



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Container No: S188609**Part:** D2893-1**Job No:** 194240**Serial No/Batch:** S188609**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 06/07/19

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				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	• AB 19-6-12
140 QC 3	12 pcs	5/31/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	DAS
				QC 3 - 40	JUN 13 2019 40
				QC 3 - 19	9-89
170 Packaging 3-1 - Stock - B4B	12 pcs	5/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	LG 050 JUN 14 2019 74
				Packaging 3 - 5 - B4B	9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	12 pcs	5/31/19	0.00 0.00	QC 21 - SA - 21	DAS JUN 17 2019
				QC 21 - SA - 70	9-89

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QC 21 - SA - 53

Part Op 100 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA081

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 5132100 exp 11/20

140 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____) LOCATION : LG050

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	6 pcs (.5 ea)	100-HAAS 4 Axis	5180904

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK078	6	8	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	194240
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.990	2.989	2.990	2.990	2.989
AB	0.440	0.460		.460	.455	.451	.455	.456
AC	0.125	0.160		.160	.160	.143	.154	.155
AD	0.040	0.060		.052	.051	.051	.050	.051
AE	0.188	0.193		.188	.188	.187	.187	.188
AF	0.125	0.160		.139	.140	.146	.143	.145
AG	0.140	0.160		.149	.150	.142	.151	.150
AH	1.360	1.400		1.376	1.377	1.383	1.382	1.385
AI	0.040	0.060		.04	.047	.054	.051	.052
AJ	1.190	1.230		1.219	1.218	1.228	1.225	1.229
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		0.063	0.063	0.063	.063	.063
AM	0.240	0.260		0.250	0.250	0.250	.250	.250
AN	2.518	2.538		2.533	2.535	2.530	2.531	2.526
AO	84.39	90.39		87.00	87.00	87.0	87.0	87.0
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		0.063	0.063	0.063	.063	.063
AR								
AS								
AT								

Accept/Reject

Measured by:	<i>[Signature]</i>	Date:	2019/06/05
Audited by:	<i>[Signature]</i>	Date:	19-06-11
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 194240
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	72	83	94	105
HAAS Section								
AA	2.985	3.005		2.990	2.989	2.989	2.990	2.990
AB	0.440	0.460		.457	.456	.451	.455	.456
AC	0.125	0.160		.157	.153	.157	.154	.153
AD	0.040	0.060		.051	.052	.052	.051	.052
AE	0.188	0.193		.186	.188	.187	.187	.187
AF	0.125	0.160		.131	.142	.144	.140	.143
AG	0.140	0.160		.151	.154	.152	.151	.153
AH	1.360	1.400		1.382	1.370	1.368	1.372	1.367
AI	0.040	0.060		.042	.050	.049	.050	.050
AJ	1.190	1.230		1.212	1.215	1.209	1.218	1.219
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.521	2.534	2.521	2.530	2.525
AO	84.39	90.39		87	87	87	87	87
AP	0.261	0.266		.250	.250	.250	.250	.250
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: DAS 71	Date:
Audited by: K. 9-89	Date: 19-06-11
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

- Checksheet

Required jack
operator -